

Date: Monday, 11/21/2005 7:58:56 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 24939		
Estimate Number	: 10564		
P.O. Number	: N/A	Part Number	: D34433
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D3443 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 11/28/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	2 Um: Each
Comment	: Est Rev: A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R3000	Inventory
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Comment: Qty.: 1.0000 f(s)/Unit Total : 2.0000 f(s)

Material: AISI 304 SS Round Bar Ø1.500

(M304R1.500)

Batch: 519052

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: N/A &DWG REV: AEC 05.11.22

2-DEBURR AS REQUIRED

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE EC 05.11.22

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: A & Dwg D3443 Rev: A

2-Deburr per dwg D3443

M8 05/11/222

P10

Prod. Eng. CP
 Prod. Eng.
 P

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/11/09	4.0	depth of cut too big made part turn in fixture prog. error.		prog has been fixed. N/A prototype	MS 05/11/09			
				EC				

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



MB 05/11/22



2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Drill hole as per Dwg D3443.

MB 05.11.22

2

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MB 05.11.23

2

8.0

QC8

SECOND CHECK



MB 05/11/23



2

Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: N/A

MB 05.11.23

2

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

MB 05/11/23

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

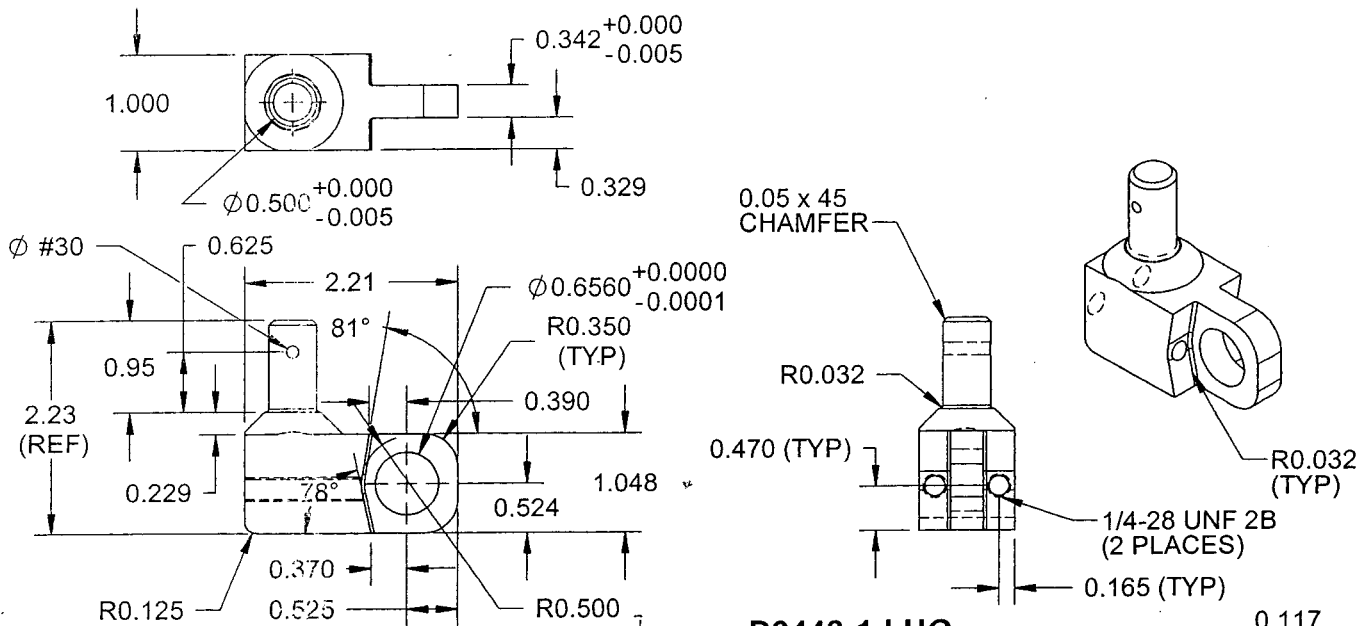
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

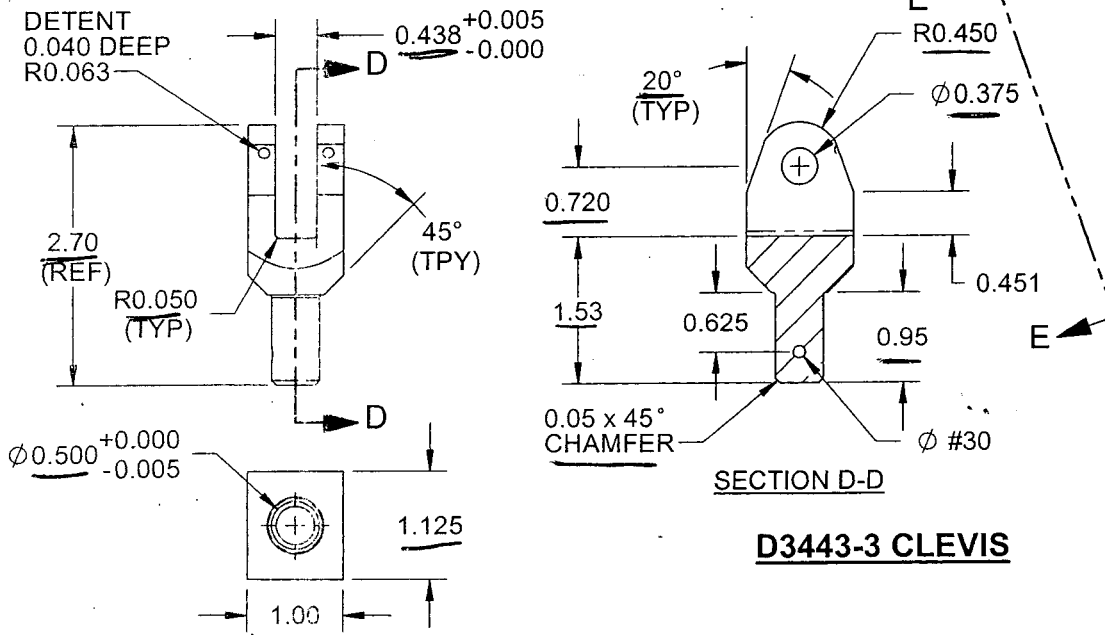
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3443	REV. A SHEET 2 OF 3
DATE 05.09.02		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.010

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